Amendments To The Claims:

Claim 1 (original). A flexible, thermoplastic, biaxially stretched, heat shrinkable film having at least one layer comprising a blend of at least three copolymers comprising:

25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one unmodified or anhydride-modified copolymer of ethylene and a vinyl ester, acrylic acid, methacrylic acid or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and wherein said film has a shrinkage value at 90°C of at least 45% in at least one of the machine direction or transverse direction, and said film has a ram puncture force of at least 65 Newtons.

Claim 2 (original). A polymer film, as defined in Claim 1, wherein said first polymer has a melting point of from 80 to 85°C.

Claim 3 (original). A polymer film, as defined in Claim 1, wherein said first polymer is a bipolymer.

Claim 4 (original). A polymer film, as defined in Claim 1, wherein said first polymer is a terpolymer comprising: ethylene, hexene-1 and octene-1; or ethylene, butene-1 and octene.

Claim 5 (original). A polymer film, as defined in Claim 1, wherein said second polymer comprises a copolymer of ethylene and octene-1.

Claim 6 (previously presented). A polymer film, as defined in Claim 1, wherein said third polymer is selected from the group consisting of ethylene vinyl acetate copolymer, ethylene methylacrylate copolymer, ethylene butylacrylate copolymer, and ethylene ethylacrylate copolymer.

Claim 7 (original). A film, as defined in Claim 1, wherein said third polymer comprises a copolymer of ethylene and vinyl acetate.

Claim 8 (original). A film, as defined in Claim 1, further comprising a fourth polymer having a melting point of from 91 to 110°C.

Claim 9 (original). A film, as defined in Claim 1, having a haze value of less than 10%.

Claim 10 (original). A film, as defined in Claim 1, wherein said film has a shrinkage value at 80°C of at least 30% in at least one of the machine and transverse directions.

Claim 11 (original). A film, as defined in Claim 1, wherein said film has a shrinkage value at 80°C of at least 35% in at least one of the machine and transverse directions.

Claim 12 (original). A film, as defined in Claim 1, wherein said film has a shrinkage value at 80°C of at least 35% in both the machine and transverse directions.

Claim 13 (previously presented). A film, as defined in Claim 1, wherein said film has a shrinkage value at 80°C of at least 45% in at least one of the machine and transverse directions.

Claim 14 (original). A film, as defined in Claim 1, wherein said film has a shrinkage value at 90°C of at least 45% in both the machine and transverse directions.

Claim 15 (original). A film, as defined in Claim 1, wherein said film has a total energy at maximum puncture force of at least 0.60 Joule.

Claim 16 (original). A film, as defined in Claim 1, wherein said film has a total energy at maximum puncture force of at least 0.80 Joule.

Claim 17 (original). A film, as defined in Claim 1, wherein said film has a total energy at maximum puncture force of at least 1.0 Joule.

Claim 18 (original). A film, as defined in Claim 1, wherein said film has a maximum ram puncture force of at least 100 Newtons.

Claim 19 (original). A film, as defined in Claim 1, wherein said film has a maximum ram puncture force of at least 110 Newtons.

Claim 20 (original). A film, as defined in Claim 1, wherein said film has a ram puncture stress of at least 140 MPa.

Claim 21 (original). A film, as defined in Claim 1, wherein said first polymer has a $\overline{M}_w/\overline{M}_n$ of from 1.5 to 3.0.

Claim 22 (original). A film, as defined in Claim 1, wherein said first polymer has a $\overline{M}_w/\overline{M}_n$ of from 2.2 to 2.7.

Claim 23 (original). A film, as defined in Claim 1, wherein said first polymer has a melt index of from 1.5 to 3.0 dg/min.

Claim 24 (original). A film, as defined in Claim 1, wherein said first polymer has a melt index of from 0.3 to 1.5 dg/min.

Claim 25 (original). A film, as defined in Claim 1, wherein said first polymer has a melt index less than 2.5 dg/min.

Claim 26 (original). A film, as defined in Claim 1, further comprising at least one additional other thermoplastic layer.

Claim 27 (original). A film, as defined in Claim 1, further comprising at least three additional thermoplastic layers.

Claim 28 (previously presented). A film, as defined in Claim 1, wherein said layer comprising a blend has been irradiatively crosslinked.

Claim 29 (previously presented). A film, as defined in Claim 1, wherein said film forms a tube having an inner heat sealing layer comprising said blend.

Claim 30 (original). A film, as defined in Claim 1, wherein said film is fabricated into bags.

Claim 31 (previously presented). A film, as defined in Claim 26, wherein said additional layer comprises a gas barrier layer and said film has an oxygen transmission rate of less than 15 cc/100 in^2 for 24 hrs. at 1 atm at 23°C.

Claim 32 (previously presented). A film, as defined in Claim 26, wherein said film is a tubular multilayer film formed by coextrusion or coating lamination and said tubular film has an inner heat sealing layer comprising said blend.

Claim 33 (original). A film, as defined in Claim 1, wherein said blend comprises at least 50 percent by weight of said layer based on the total weight of the layer.

Claim 34 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of from 25 to 45 weight percent, based upon the total weight of the first, second and third polymers.

Claim 35 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of from 30 to 40 weight percent, based upon the total weight of the first, second and third polymers.

Claim 36 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of from 45 to 85 weight percent, based upon the total weight of the first, second and third polymers.

Claim 37 (original). A film, as defined in Claim 1, wherein said first polymer is present in an amount of from 50 to 85 weight percent, based upon the total weight of the first, second and third polymers.

Claim 38 (original). A film, as defined in Claim 1, wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 39 (original). A film, as defined in Claim 1, wherein at least one interpolymer comprises said first and second polymers.

Claim 40 (previously presented). A film, as defined in Claim 27, wherein said film comprises:

a first heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

a second intermediate layer;

a third core layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

a fourth surface layer;

wherein at least one of said second and said fourth layers comprise a blend of at least three copolymers comprising:

25 to 85 weight percent of a first polymer having a melting point of 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of 60 to 110°C comprising at least one unmodified or anhydride-modified copolymer of ethylene and a vinyl ester, acrylic acid,

methacrylic acid or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and wherein said film has a shrinkage value at 90°C of at least 45% in at least one of the machine direction or transverse direction, and said film has a maximum ram puncture force of at least 65 Newtons; and said core layer is disposed between said second and said fourth layers.

Claim 41 (original). A film, as defined in Claim 40, wherein said film has a shrinkage value at 80°C of at least 30% in at least one of the machine and transverse directions.

Claim 42 (original). A film, as defined in Claim 40 or 41, wherein said film has a tensile seal strength of at least 400 g/cm at 88°C.

Claim 43 (original). A film, as defined in Claim 40, wherein said film has a tensile seal strength of at least 600 g/cm at 88°C.

Claim 44 (original). A film, as defined in Claim 40 or 41, wherein said film has a hot water puncture resistance value of at least 40 seconds at 95°C.

Claim 45 (original). A film, as defined in Claim 40, wherein said film has a hot water puncture resistance value of at least 100 seconds at 95°C.

Claim 46 (original). A film, as defined in Claim 40 or 41, wherein said film has an average hot water seal strength of at least 200 seconds at 95°C.

Claim 47 (original). A film, as defined in Claim 40 or 41, wherein said film has an average hot water seal strength of at least 300 seconds at 95°C.

Claim 48 (original). A film, as defined in Claim 1 or 40, wherein said film has a ram puncture stress of at least 200 MPa.

Claim 49 (original). A film, as defined in Claim 40, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 50 (original). A biaxially stretched, heat shrinkable film comprising a blend of: (i) an interpolymer comprising at least a copolymer of ethylene and octene-1 and having a first melting point of from 55 to 95°C and a second melting point of from 115 to 128°C, and (ii) a polymer having a melting point of from 60 to 110°C comprising an unmodified or anhydride-modified copolymer of ethylene and a vinyl ester, acrylic acid, methacrylic acid, or alkyl acrylate; said film having a shrinkage value at 90°C of at least 45% in at least one of the machine and transverse directions.

Claim 51 (original). A flexible, thermoplastic, biaxially stretched, heat shrinkable film having at least one layer comprising a blend of at least three copolymers comprising:

45 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one unmodified or anhydride-modified copolymer of ethylene and a vinyl ester, acrylic acid, methacrylic acid, or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and wherein said film has a total energy absorption of at least 0.70 Joule and a shrinkage value at 90°C of at least 50% in at least one of the machine and transverse directions.

Claim 52 (previously presented). A film, as defined in Claim 51, wherein said first polymer comprises 50 to 85 weight % of said blend.

Claim 53 (original). A film, as defined in Claim 51, wherein said film has a maximum puncture force of at least 90 Newtons.

Claim 54 (original). A film, as defined in Claim 51, wherein said film has a shrinkage value at 80°C of at least 35% in at least one of the machine and transverse directions.

Claim 55 (original). A film, as defined in Claim 51, wherein said film has a shrinkage value at 80°C of at least 35% in both the machine and transverse directions.

Claim 56 (original). A film, as defined in Claim 51, wherein said film has a shrinkage value at 80°C of at least 50% in at least one of the machine and transverse directions.

Claim 57 (original). A film, as defined in Claim 51, wherein said film has a shrinkage value at 80°C of at least 50% in both the machine and the transverse directions.

Claim 58 (original). A film, as defined in Claim 51, wherein said film has a total energy absorption of at least 0.90 Joules.

Claim 59 (original). A film, as defined in Claim 51, wherein said film has a maximum stress of at least 200 MPa.

Claim 60 (original). A film, as defined in Claim 51 or 52, wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 61 (original). A film, as defined in Claim 51, further comprising at least one additional thermoplastic layer.

Claim 62 (original). A film, as defined in Claim 51, further comprising at least four additional thermoplastic layers.

Claim 63 (previously presented). A film, as defined in Claim 51 or 52, wherein said film comprises:

a first heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

a second intermediate layer;

a third core layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

a fourth surface layer;

wherein at least one of said second and said fourth layers comprise said blend of at least three copolymers, and said core layer is disposed between said second and said fourth layers.

Claim 64 (original). A film, as defined in Claim 63, wherein said film has a tensile seal strength of at least 400 g/cm at 88°C.

Claim 65 (original). A film, as defined in Claim 63, wherein said film has a hot water puncture resistance value of at least 40 seconds at 95°C.

Claim 66 (original). A film, as defined in Claim 63, wherein said film has a hot water puncture resistance value of at least 100 seconds at 95°C.

Claim 67 (original). A film, as defined in Claim 63, wherein said film has an average hot water seal strength of at least 200 seconds at 95°C.

Claim 68 (original). A film, as defined in Claim 63, wherein said film has an average hot water seal strength of at least 300 seconds at 95°C.

Claim 69 (original). A film, as defined in Claim 63, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 70 (original). A biaxially stretched, heat shrinkable film comprising at least three layers, wherein said first layer comprises a blend of at least three polymers comprising: a first polymer having a melting point of from 55 to 95°C comprising a copolymer of ethylene and octene-1; a second polymer having a melting point of from 115 to 128°C comprising a copolymer of ethylene and at least one α-olefin; a third polymer having a melting point of from 60 to 110°C comprising a copolymer ethylene and a vinyl ester or alkyl acrylate; a third layer comprising at least 50 percent by weight of copolymer of ethylene with at least one alpha-olefin or at least one vinyl ester or blends thereof, and a second layer between said first and third layers; said second layer comprising a vinylidene chloride copolymer, a nylon or a copolymer of ethylene with a vinyl alcohol; said film having a maximum ram puncture force of at least 65 Newtons, a total energy absorption of at least 0.50 Joule, and a shrinkage value at 90°C of at least 45% in at least one of the machine and transverse directions..

Claim 71 (original). A film, as defined in Claim 70, wherein said film has a shrinkage value at 90°C of at least 45% in both of the machine and transverse directions.

Claim 72 (original). A film, as defined in Claim 70, wherein said film has a shrinkage value at 80°C of at least 35% in at least one of the machine and transverse directions.

Claim 73 (original). A film, as defined in Claim 70, wherein said film has a maximum puncture force of at least 90 Newtons.

Claim 74 (original). A film, as defined in Claim 70, wherein said film has a total energy absorption of at least 0.9 Joule.

Claim 75 (original). A film, as defined in Claim 70, wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 76 (previously presented). A film, as defined in Claim 70, wherein at least one interpolymer comprises both said first and second polymers.

Claim 77 (cancelled).

Claim 78 (cancelled).

Claim 79 (cancelled).

Claim 80 (cancelled).

Claim 81 (cancelled).

Claim 82 (currently amended). ~~A blend, as defined in Claim 77,~~ A polymer blend of at least three copolymers consisting essentially of:

25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin;

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at lease one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers; and

wherein at least one of said first, second, and third polymers comprises an interpolymer.

Claim 83 (currently amended). A blend, as defined in Claim ~~77~~ 82, wherein an interpolymer comprises both said first and second polymers.

Claim 84 (cancelled).

Claim 85 (currently amended). A flexible film ~~as defined in Claim 84~~, wherein said film comprises:

a heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer;

an outer protective surface layer;

wherein at least one of said intermediate and said outer protective layers comprise a polymer blend of at least three copolymers ~~comprising~~ consisting essentially of:

25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one unmodified or anhydride-modified copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

and said core layer is disposed between said intermediate and said outer protective layers.

Claim 86 (cancelled).

Claim 87 (cancelled).

Claim 88 (currently amended). ~~A process, as defined in Claim 86,~~ A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising at least one layer consisting essentially of 25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of from 65 to 88°C;

biaxially stretching said tube to a circumference of at least 2½ times the circumference of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film; and

wherein said resultant film has a maximum ram puncture force of at least 65 Newtons, a total energy absorption of at least 0.50 Joule, and a shrinkage value at 90°C of at least 45% in at least one of the machine and transverse directions.

Claim 89 (cancelled).

Claim 90 (currently amended). ~~A process, as defined in Claim 86~~, A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising at least one layer consisting essentially of 25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of from 65 to 88°C;

biaxially stretching said tube to a circumference of at least 2½ times the circumference of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film; and

wherein said resultant film has a maximum ram puncture force of at least 90 Newtons, a total energy absorption of at least 0.90 Joule, and a shrinkage value at 90°C of at least 50% in both of the machine and transverse directions.

Claim 91 (currently amended). ~~A process, as defined in Claim 86,~~ A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising at least one layer consisting essentially of 25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of from 65 to 88°C;

biaxially stretching said tube to a circumference of at least 2½ times the circumference of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film;

wherein a multilayer primary tube is made by coextrusion or coating lamination and said resultant biaxially stretched film comprises:

a heat sealing surface layer comprising a polymer selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer comprising at least 80% by weight, based on said third layer's weight, of at least one copolymer of: EVOH; or vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

an outer protective surface layer;

wherein at least one of said intermediate and said outer protective layers comprise, a polymer blend of at least three copolymers comprising:

25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers, and said core layer is disposed between said intermediate and said outer protective layers, and said film has a maximum ram puncture force of at least 100 Newtons, a hot water puncture resistance of at least 100 seconds at 95°C and a hot water seal strength of at least 200 seconds at 95°C.

Claim 92 (cancelled).

Claim 93 (previously presented). A biaxially stretched, heat shrinkable, multilayer film useful for food processing and packaging having at least four layers comprising:

a first heat sealing surface layer comprising a polymer or blend of polymers selected from the group consisting of: (a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and (b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

a second polymeric layer comprising a blend of (a) from 25 to 85 wt. % of a first polymer having a melting point of 55 to 95°C comprising a copolymer of ethylene and octene-1; (b) from 5 to 35 wt. % of a second polymer having a melting point of 115°C to 128°C comprising a copolymer of ethylene and at least one C_4-C_8 α-olefin; and (c) from 10 to 50 wt. % of a third polymer having a melting point of 60 to 110°C comprising a copolymer of ethylene with a vinyl ester, acrylic acid, methacrylic acid, or alkyl acrylate, wherein said first and second copolymers have a combined weight percentage of at least 50 weight percent, said weight percent being based upon the total weight of said first, second and third polymers;

a third layer comprising at least 80% by weight, based on said third layer's weight, of EVOH or at least one copolymer of vinylidene chloride with from 2 to 20 weight percent, based on said copolymer's weight, of vinyl chloride or methyl acrylate; and

a fourth polymeric layer comprising (a) from 10 to 85 wt. % of a first copolymer of ethylene and at least one C_3-C_8 α-olefin, said first copolymer having a melting point of 55 to 98°C, (b) from 5 to 60 wt. % of a second copolymer of ethylene and at least one C_4-C_8 α-olefin, said second copolymer having a melting point of 115°C to 128°C, and (c) from 0 to 50 wt. % of a third copolymer having a melting point of 60 to 110°C of ethylene with a vinyl ester, acrylic acid, methacrylic acid, or alkyl acrylate, wherein said first and second copolymers have a combined weight percentage of at least 50 weight percent, said weight percent being based upon the total weight of said layer; and

wherein said film has a shrinkage value at 90°C of at least 40% in at least one of the machine and transverse directions, and said film has a tensile seal strength of at least 400 g/cm at 88°C.

Claim 94 (original). A film, as defined in Claim 93, wherein said film has a maximum ram puncture force of at least 70 Newtons.

Claim 95 (original). A film, as defined in Claim 93, wherein said film has a maximum ram puncture force of at least 110 Newtons.

Claim 96 (original). A film, as defined in Claim 93, wherein said film has a hot water puncture resistance of at least 25 seconds at 95°C.

Claim 97 (original). A film, as defined in Claim 93, wherein said film has a hot water puncture resistance of at least 40 seconds at 95°C.

Claim 98 (original). A film, as defined in Claim 93, wherein said film has a hot water puncture resistance of at least 100 seconds at 95°C..

Claim 99 (original). A film, as defined in Claim 93, wherein said film has a hot water seal strength of at least 200 seconds at 95°C.

Claim 100 (original). A film, as defined in Claim 93, wherein said film has a hot water seal strength of at least 300 seconds at 95°C.

Claim 101 (original). A film, a s defined in Claim 93, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 102 (original). A film, as defined in Claim 93, wherein said film has a thickness less than 175 microns.

Claim 103 (original). A film, as defined in Claim 93, wherein said film has a haze value of less than 10% and a gloss at 45° of at least 70 Hunter units.

Claim 104 (original). A film, as defined in Claim 93, wherein said film has an oxygen transmission rate of less than 45 cm^3/m^2 for 24 hrs. at 1 atm. at 23°C.

Claim 105 (original). A film, as defined in Claim 93, wherein said first copolymer of at least one of said second and fourth layers has a density less than 0.900 g/cm^3.

Claim 106 (original). A film, as defined in Claim 93, wherein said first copolymer of both said second and fourth layers has a density less than 0.900 g/cm^3.

Claim 107 (previously presented). A film, as defined in Claim 93, wherein said third copolymer of both said second and fourth layers comprises 4 to 18 %, by weight of said copolymer, of a vinyl ester or 4 to 30 wt. % of an alkyl acrylate.

Claim 108 (previously presented). A film, as defined in Claim 93, wherein in said fourth polymeric layer comprises a blend of: (a) from 25 to 85 wt. % of a first polymer having a melting point of 55 to 95°C comprising a copolymer of ethylene and octene-1; (b) from 5 to 35 wt. % of a second polymer having a melting point of 115°C to 128°C comprising a copolymer of ethylene and at least one C_4-C_8 α-olefin; and (c) from 10 to 50 wt. % of a third polymer having a melting point of 60 to 110°C comprising a copolymer of ethylene with a vinyl ester, acrylic acid, methacrylic acid, or alkyl acrylate, wherein said first and second copolymers have a combined weight percentage of at least 50 weight percent, said weight percent being based upon the total weight of said first, second and third polymers.

Claim 109 (original). A film, a s defined in Claim 93, wherein said melting point of said first heat sealing surface layer polymer (b) is at least 115°C.

Claim 110 (previously presented). A film, as defined in Claim 93, wherein said copolymer of ethylene and octene-1 is present in an amount of 50 to 85 wt. %.

Claim 111 (previously presented). A film, as defined in Claim 93, wherein said copolymer of ethylene and octene-1 is present in an amount of 25 to 50 wt. %.

Claim 112 (previously presented). A polymer blend of at least three copolymers comprising:

25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers, wherein at least one of said first, second and third polymers comprises an interpolymer.

Claim 113 (previously presented). A blend, as defined in Claim 112, wherein an interpolymer comprises said first and second polymers.

Claim 114 (previously presented). A flexible film comprising at least one layer comprising the blend of Claim 112.

Claim 115 (cancelled).

Claim 116 (previously presented). A process for making biaxially stretched, heat shrinkable film comprising:

extruding a melt plastified primary tube comprising 25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers;

cooling said primary tube;

reheating said cooled tube to a draw point temperature of from 65 to 88°C;

biaxially stretching said tube to a circumference of at least 2½ times the circumference of said primary tube, and cooling said biaxially stretched tube to form a biaxially stretched, heat shrinkable film;

wherein said resultant film has a maximum ram puncture force of at least 65 Newtons, a total energy absorption of at least 0.50 Joule, and a shrinkage value at 90°C of at least 45% in at least one of the machine and transverse directions.

Claim 117 (previously presented). A process, as defined in Claim 116, wherein said resultant film has a maximum ram puncture force of at least 90 Newtons, a total energy absorption of at least 0.90 Joule, and a shrinkage value at 90°C of at least 50% in both of the machine and transverse directions.

Claim 118 (previously presented). A process, as defined in Claim 116, wherein a multilayer primary tube is made by coextrusion or coating lamination and said resultant biaxially stretched film comprises:

a heat sealing surface layer comprising a polymer selected from the group consisting of:

(a) at least 50% by weight of a copolymer of propene and at least one α-olefin selected from the group consisting of ethylene, butene-1, methylpentene-1, hexene-1, octene-1 and mixtures thereof having a propene content of at least 60 wt. %, and

(b) at least 50% by weight of a copolymer of ethylene and at least one α-olefin selected from the group consisting of propylene, butene-1, methylpentene-1, hexene-1, octene-1, and mixtures thereof having a melting point of at least 105°C and a density of at least 0.900 g/cm^3;

an intermediate layer;

a core layer comprising at least 80% by weight (based on said third layer's weight) of at least one copolymer of: EVOH; or vinylidene chloride with from 2 to 20 weight percent (based on said copolymer's weight) of vinyl chloride or methyl acrylate; and

an outer protective surface layer;

wherein at least one of said intermediate and said outer protective layers comprise a polymer blend of at least three copolymers comprising:

25 to 85 weight percent of a first polymer having a melting point of from 55 to 95°C comprising at least one copolymer of ethylene and octene-1;

5 to 35 weight percent of a second polymer having a melting point of from 115 to 128°C comprising at least one copolymer of ethylene and at least one α-olefin; and

10 to 50 weight percent of a third polymer having a melting point of from 60 to 110°C comprising at least one copolymer of ethylene and a vinyl ester or an alkyl acrylate; wherein said first and second polymers have a combined weight percentage of at least 50 weight percent, said weight percentage being based upon the total weight of said first, second and third polymers, and said core layer is disposed between said intermediate and said outer protective layers, and said film has a maximum ram puncture force of at least 100 Newtons, and a hot water seal strength of at least 200 seconds at 95°C.